



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4275-1

Job Sheet 180388



Part No: D4275-1

Job Qty: 3 ea

Part Name: Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 7/13/18

Description:

Type: Stock

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV.A DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Machining-2	mml	DJP
100	Bandsaw	3 pcs	7/13/18	7/13/18	0.00	0.31	Bandsaw1	11	DJP
110	CNC Vertical Machining	3 pcs	7/13/18	7/13/18	0.71	5.56	HAAS1-4	11	DJP
120	QC	3 pcs	7/13/18	7/13/18	0.00	0.00	QC2 Machining-2	11	DJP
130	QC	3 pcs	7/13/18	7/13/18	0.00	0.00	QC8 Machining-2	11	DJP
140	HandFinish	3 pcs	7/13/18	7/13/18	0.00	0.45	HandFinish1	11	DJP
145	Powdercoat	3 pcs	7/13/18	7/13/18	0.00	0.38	Powdercoat1	11	DJP
150	QC	3 pcs	7/13/18	7/13/18	0.00	0.00	QC3	11	DJP
180	Packaging	3 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-2	5/463	JAS
190	QC21-SA	3 Ea	7/13/18	7/13/18	0.00	0.00	QC21	21	JAS

Part Op 100 - Cut Blank to 39.750" Batch:

Descriptions: 110 - 1-Machine per folio FB006 2- deburr rough edges

145 - MASK AS PER DWG

11/35839 START: 3:55. OUT: 3:00. FINISH: 4:25.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	9.9375 ft (3.3125 ea)	90-Start up Operation	5090370

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X04.000	10	9	0

Specifications

s could not be found.

Plex 7/5/18 1:45 PM dart.lacelle.linda



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S091812



Part: D4275-1

Job No: 180388

Serial No/Batch: S091812

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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DART AEROSPACE LTD		Work Order:	180388
Description: Fwd Beam		Part Number:	D4275-1
Inspection Dwg: D4275 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.751	✓		vern	max L-5
26.700	+/-0.010	26.700	✓			
Ø0.381	+0.000/-0.001	0.380	✓			
8.280	+/-0.010	8.280	✓			
1.44	+/-0.030	1.440	✓			
0.95	+/-0.030	0.950	✓			
3.50	+/-0.030	3.504	✓			
13.28	+/-0.030	13.280	✓			
13.50	+/-0.030	13.500	✓			
9.25	+/-0.030	9.250	✓			
5.00	+/-0.030	5.00	✓			
0.75	+/-0.030	0.750	✓			
2.75	+/-0.030	2.750	✓			
3.00	+/-0.030	3.001	✓			
1.250	+/-0.010	1.250	✓			
4.50	+/-0.030	4.500	✓			
0.734	+/-0.010	.736	✓			
0.108	+/-0.010	.106	✓			
39.48	+/-0.030	39.48	✓			
0.95	+/-0.030	0.950	✓			
0.60	+/-0.030	0.600	✓			
1.750	+/-0.010	1.750	✓			
2.700	+/-0.010	2.697	✓			
1.10	+/-0.030	1.102	✓			
1.25	+/-0.030	1.249	✓			
0.900	+/-0.010	0.900	✓			
0.75	+/-0.030	0.750	✓			
0.250	+/-0.010	0.250	✓			
3.000	+/-0.010	2.999	✓			
1.500	+/-0.010	1.500	✓			
Ø0.191	+0.005/-0.001	0.1925	✓			

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